

Work Order ID 66918

Wednesday, March 02, 2011 2:48:00 PM

Page 1

Item ID: D4191-13

Accept

Revision ID: PRELIM

Item Name: Cable Adapter

Start Date: 3/2/2011 Start Qty: 2.00

Required Date: 3/25/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *C2*Date: *11/03/02* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4191

PA+ PA6

100

0.00



Doosan

DOOSAN LATHE

Memo

1- Turn as per Folio FA991

Folio Rev: *n/a*Dwg Rev: *PA6*

3-Deburr per dwg

0.00

Doosan Lathe

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


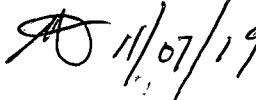

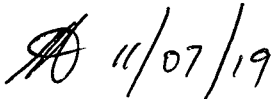


Work Order ID 66918

Page 2

Wednesday, March 02, 2011 2:48:00 PM

Item ID: D4191-13 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Cable Adapter
Start Date: 3/2/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 3/25/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Mill Conv Conventional Milling Machine	Memo DRILL LOCK WIRE HOLES AS PER DWG	0.00 0.00		11/07/19		2			
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		11/07/19		2			
150  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11-07-19		2			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66918

Wednesday, March 02, 2011 2:48:00 PM



Page 3

Item ID: D4191-13

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Cable Adapter

Start Date: 3/2/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Packaging	Identify as per dwg & Stock Location: <u>O-lvc</u> Memo	0.00 0.00							<u>4/1/11</u> (2)
190 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

RD2334

ME
11-07-19

POSITIVE RECALL
EFFECTIVE 11-03-07 AUTH W
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, March 02, 2011 2:47:56 PM

Work Order ID: 66918



Parent Item: D4191-13



Parent Item Name: Cable Adapter


Start Date: 3/2/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.625  HEX BAR .625		Purchased	No			100	f	0.0000	0.15	0.315789		11.3.28	

M117142 303 R 750 .333

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

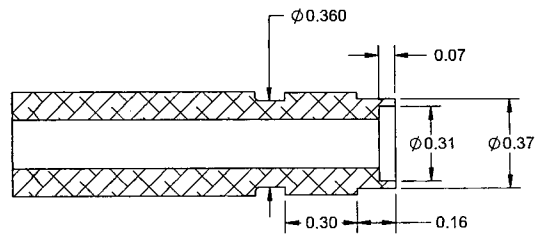
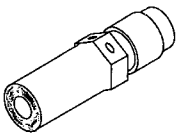
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

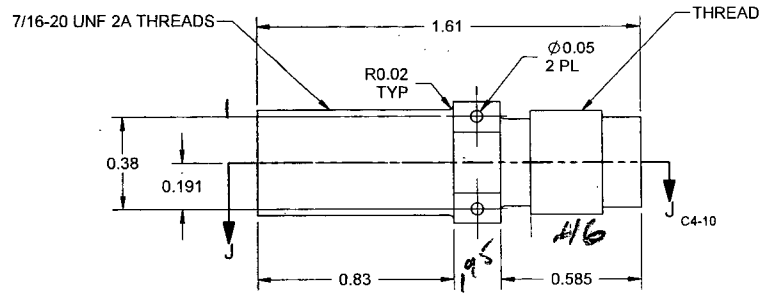
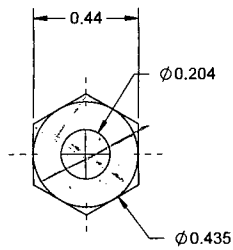
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

577



SECTION J-J B5-10



D4191-13 CABLE ADAPTER

127
0
254
22 A
A
7AN 30
0
22
127

0
A

78

C211103/02

W10: 66918

- NOTES:
- 1) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR
REF DART SPEC M303H0.625
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs

PRELIMINARY ISSUE
10.11.17

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA6
MFG. APPR.		D4191 SHEET 10 OF 12
APPROVED		TITLE SCALE
DE APPR.		CONTROL BOX NTS
DATE	10.11.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 66918
Description: Cable Adapter		Part Number: D4191-13
Inspection Dwg:	Rev: PA6	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.0 Ø	+/- .010	.358	/		RQ .02	
.07	+/- .030	.068	/			
.37	+/- .030	.360	/			
.31	+/- .030	.313	/			
.30	+/- .030	.300	/			
.16	+/- .030	.150	/			
.44	+/- .030	.443	/			
.204	+ .005 - .001	.206	/			
.435 Ø	+/- .010	.433	/		RQ .06	
1.61	+/- .030	1.611	/			
R.02	+/- .030	R.015	/			
.38	+/- .030		/			
.191	+/- .010		/			
.83	+/- .030	.830	/			
.585	+/- .010	.584	/			
.05 Ø	+ .004 - .001		/			
7/16-20	2A					
Major Ø	.4362 / .4281	.433	/		RQ .06	
M.O.W.	.4474 / .4432	.445	/		RQ .06	

Measured by: <i>[Signature]</i>
Date: 11.3.28

Audited by: <i>[Signature]</i>
Date: 11.07.19

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15